

Work Order ID 69748

Wednesday, May 18, 2011 12:30:35 PM



Page 1

Item ID: D3325-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3325	Rev B

100



Large Fab

0.00

11.05.24

Large Fab

Memo

0.00

1-Cut tubes as per Dwg D3325

Qty Part Number Description Batch
 2 D3325-1 EndTube M112786
 3 D3325-3 Interior Tube M112786
 2 D3325-5 Full Lengh Tube M112786

✓ Identify parts appropriately

✓ 2-Remove all markings from material

✓ 3-Drill and Weld as per Dwg D3325 & QSI 004
A/R 4130 Steel Rod M100075

✓ 4-Deburr as required

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 69748

Page 2

Wednesday, May 18, 2011 12:30:35 PM

Item ID: D3325-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

110



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

1 8 861105/26

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Wlctz

0.00

121



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

1 BH 11-5-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69748

Page 3

Wednesday, May 18, 2011 12:30:35 PM

Item ID: D3325-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
StampInsp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

W1169641.

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30 100°

8:00

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 BL 11-5-27.

1 6 11 105 122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69748

Page 4

Wednesday, May 18, 2011 12:30:35 PM

Item ID: D3325-041

Accept



Setup

Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

88 11/05/27

①

11/15/2011

MF

11-05-27

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 12:30:41 PM

Page 1

Work Order ID: 69748



Parent Item: D3325-041



Parent Item Name: Basket Lid Assembly

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A□05.02.09□New issue□KJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1 		Manufactured	No			100	Each	31.0000	2	2		<i>AD</i>	<i>11.05.24</i>
Basket Hinge							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005 <i>33871</i>				31 31				<i>2</i>	
D3349-1 		Manufactured	No			100	Each	36.0000	2	2		<i>AD</i>	<i>11.05.24</i>
Spacer Bushing							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005 <i>34205</i> 44401				36 8 28			<i>2</i>		
D3352-1 		Manufactured	No			100	Each	18.0000	1	1		<i>AD</i>	<i>11.05.24</i>
Label Plate							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005 <i>41925</i>				18 18			<i>1</i>		
D3367-1 		Manufactured	No			100	Each	36.0000	2	2		<i>AD</i>	<i>11.05.24</i>
Mounting Bracket							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005 <i>43228</i>				36 36			<i>2</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, May 18, 2011 12:30:41 PM

Work Order ID: 69748



Parent Item: D3325-041



Parent Item Name: Basket Lid Assembly

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased No

100

f

555.7500

20.5416

21.62274



11.05.24

4130 Square tube .500 x .500 x .035w

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	555.75	
109127	216	
109385	15.75	
112786	324	

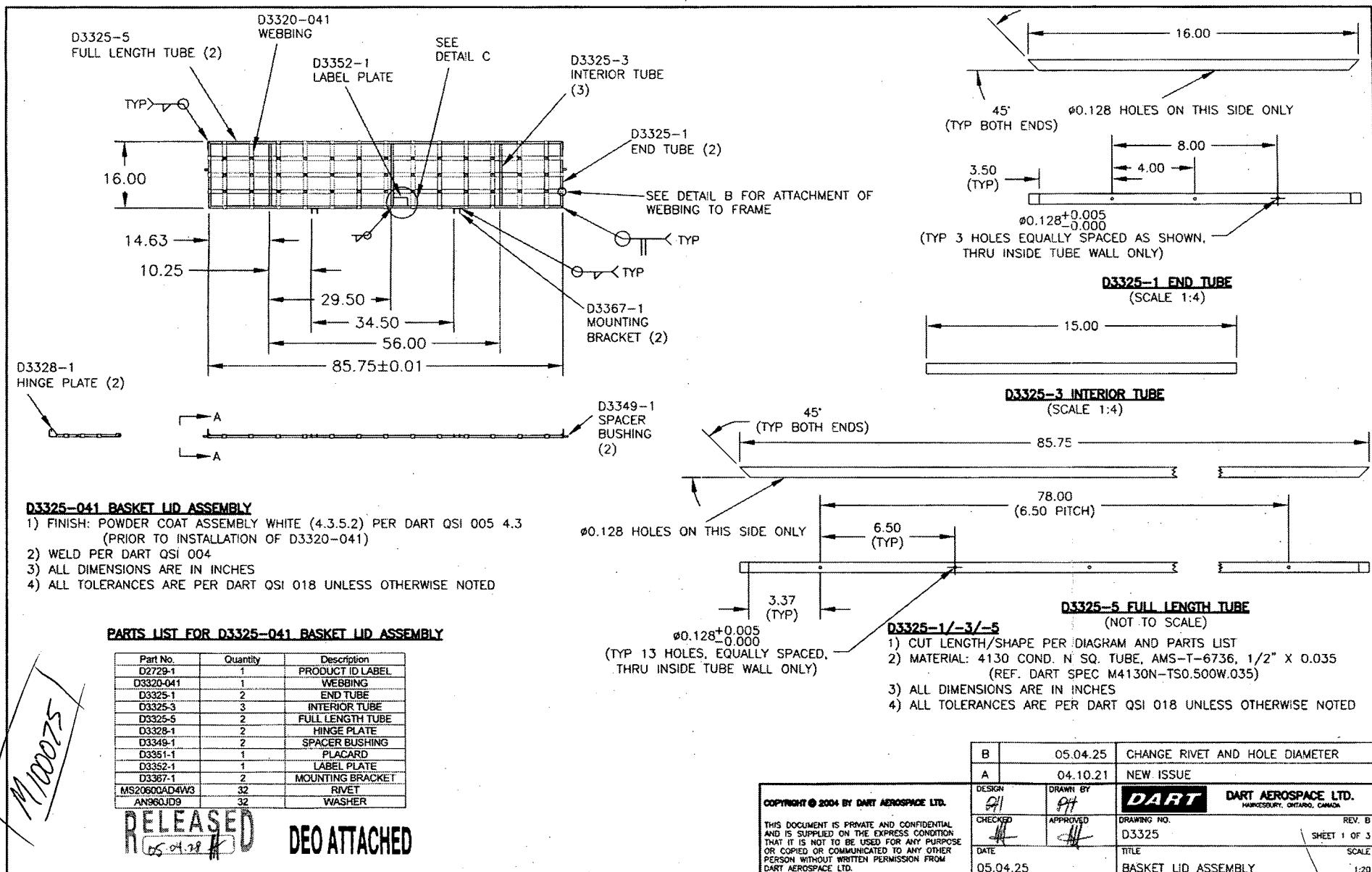
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

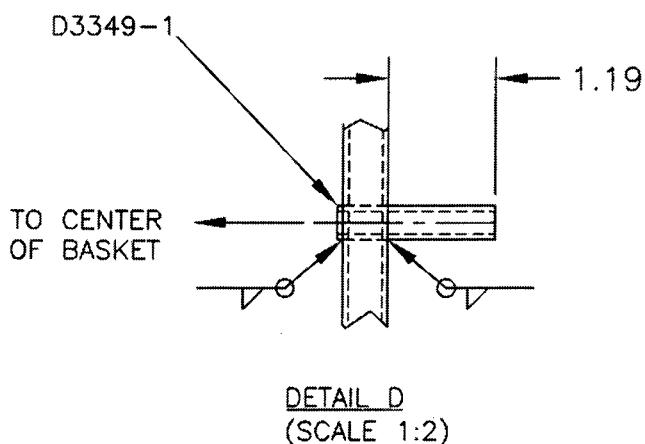
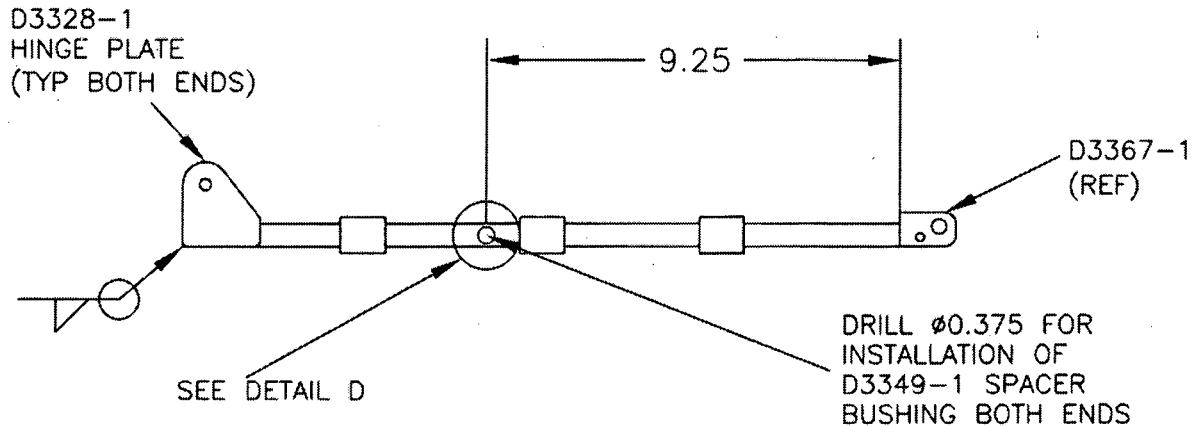
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

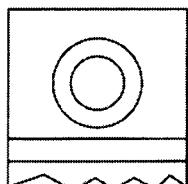
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

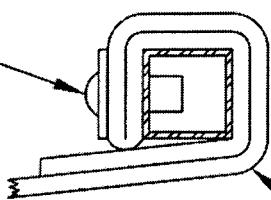


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. 6 SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



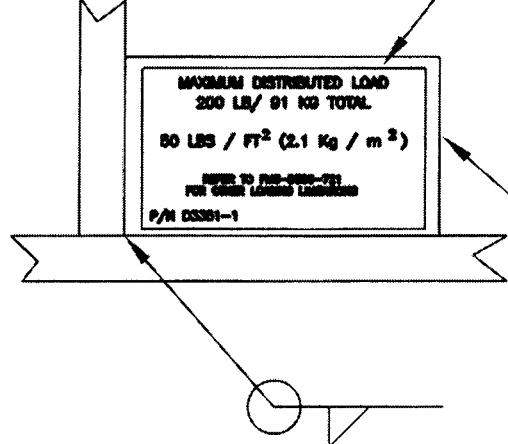
DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)



D3320-041 WEBBING

RELEASED
05.04.28 *PH*
DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UndERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE 08.11.28	AJS DATE 08.11.28	CHECKED DATE 08.11.28	MFG. APPR. DATE 08.12.01	APPROVED DATE 08.12.01	DE APPR. DATE 08.12.01	

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries